Work Order ID 112280

January-30-14 11:25:31 AM

112280

Item ID: D2013-4
Revision ID:
Item Name: Mirror Bracket RH, 212
Start Date: 2/17/14 **Start Qty:** 4.00 *4*
Required Date: 2/21/14 **Req'd Qty:** 4.00 *4*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*
Cust Item ID:
Customer:

Approvals: **Process Plan:** MLS **Date:** 14-01-31 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2013	**Revision Nbr** Rev C								
100	NC BRAKE	0.00							FF 14-04-07
100 Brake NC		0.00				4			
Brake NC	**Memo** 1-Punch as per template D2013-T3 and Dwg D2013 2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 Identify as D2013-3. 4-Deburr as required								
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 27 9-39 14/4/9
110 QC		0.00				4			
Quality Control	**Memo**								

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Work Order ID 112280

January-30-14 11:25:31 AM

112280

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Start Date: 2/17/14 **Start Qty:** 4.00 *4*
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Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: WA001	0.00							
120 Packaging	Memo	0.00				(4)		JE	14.04.10
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130 QC	Memo	0.00						14/4/10	
Quality Control									

14.04.10

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

January-30-14 11:25:31 AM

Work Order ID: **112280**

Parent Item: **D2013-4**

Parent Item Name: Mirror Bracket RH, 212

Start Date: 2/17/14 **Required Date:** 2/21/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049 304 RD Tube .750 x .049W		Purchased	No			100	f	358.4967	**1.9473**	**8.199158**			

FF 14-0407

Location	Loc Qty	Loc Code	
MAT017	358.4967		
122312	10		
124768	49.27		
M126183	99.2267		8.1991
M128084	200		

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

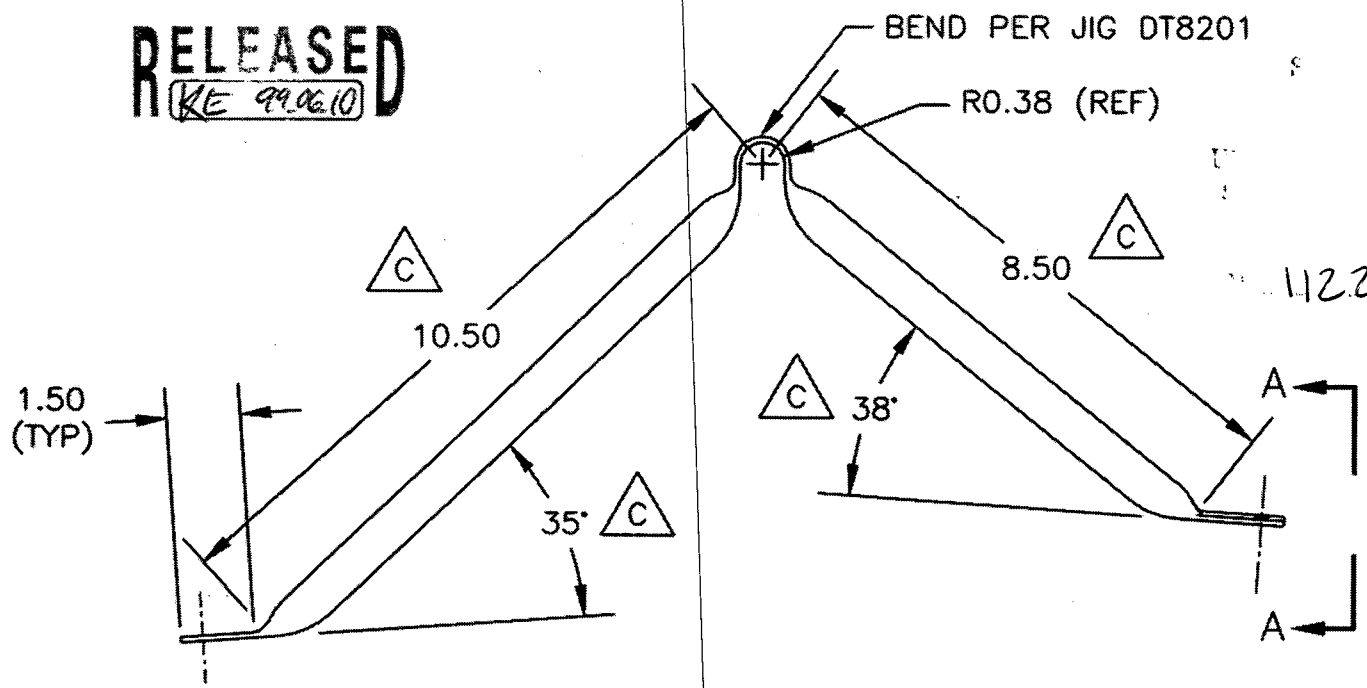
Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

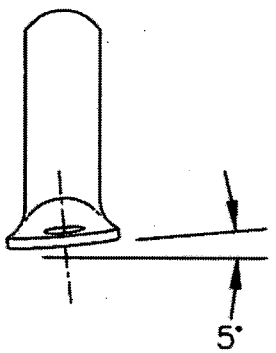
- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
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- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
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- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

RELEASED
KE 99.06.10

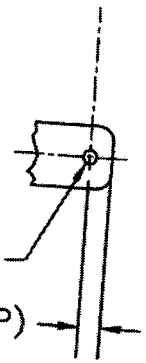


112280 MCS
140203

D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



VIEW A-A



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

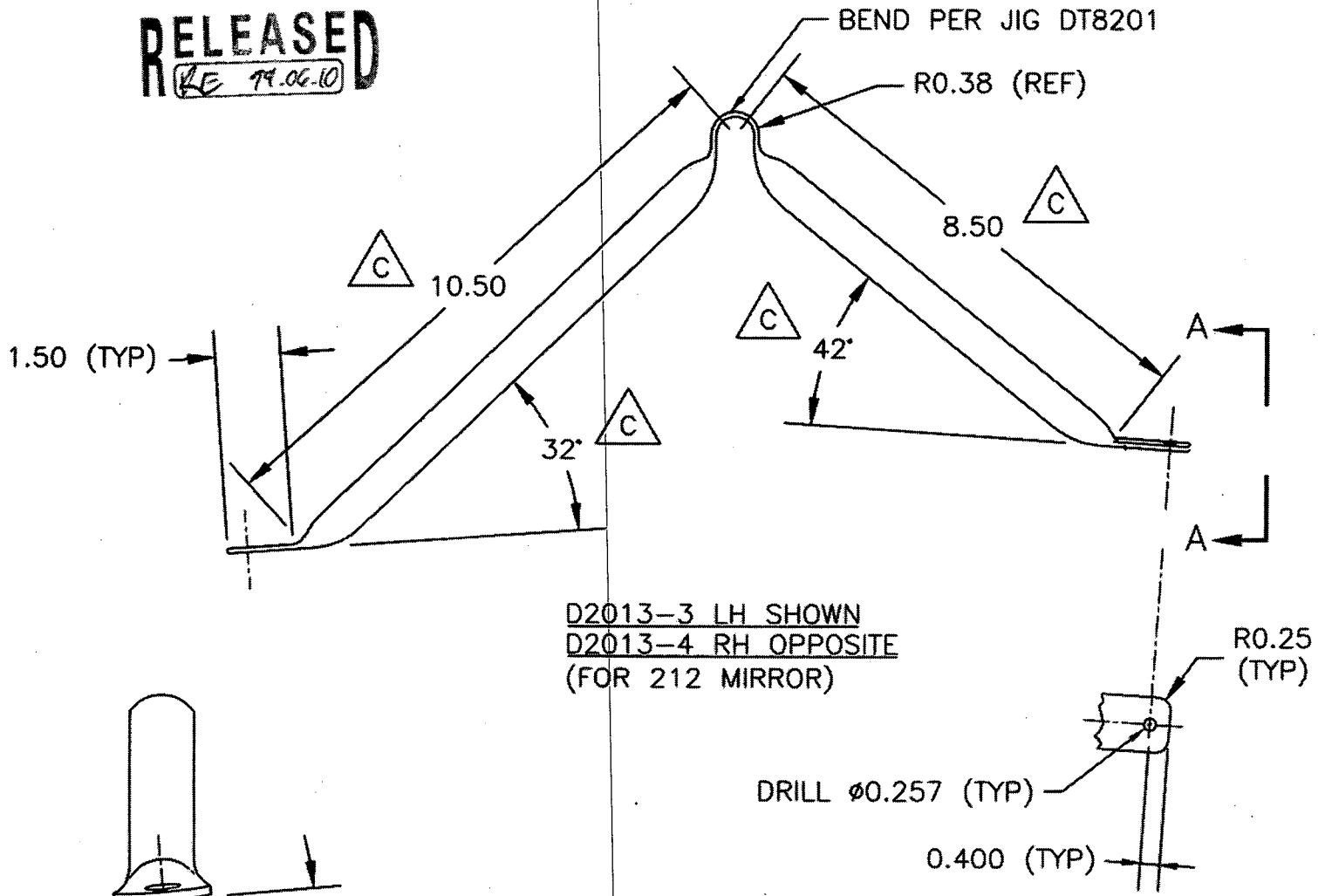
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS
B	94.06.15	REDRAWN
A	90.10.22	NEW ISSUE

DESIGN: JB
DRAWN BY: RF
CHECKED: KE
APPROVED:
DATE: 99.06.07
TITLE: MIRROR BRACKET
DRAWING NO.: D2013
REV. C
SHEET 1 OF 3
SCALE: NTS

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

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RELEASED
KE 99.06.10



D2013-3 LH SHOWN
D2013-4 RH OPPOSITE
(FOR 212 MIRROR)

VIEW A-A

CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

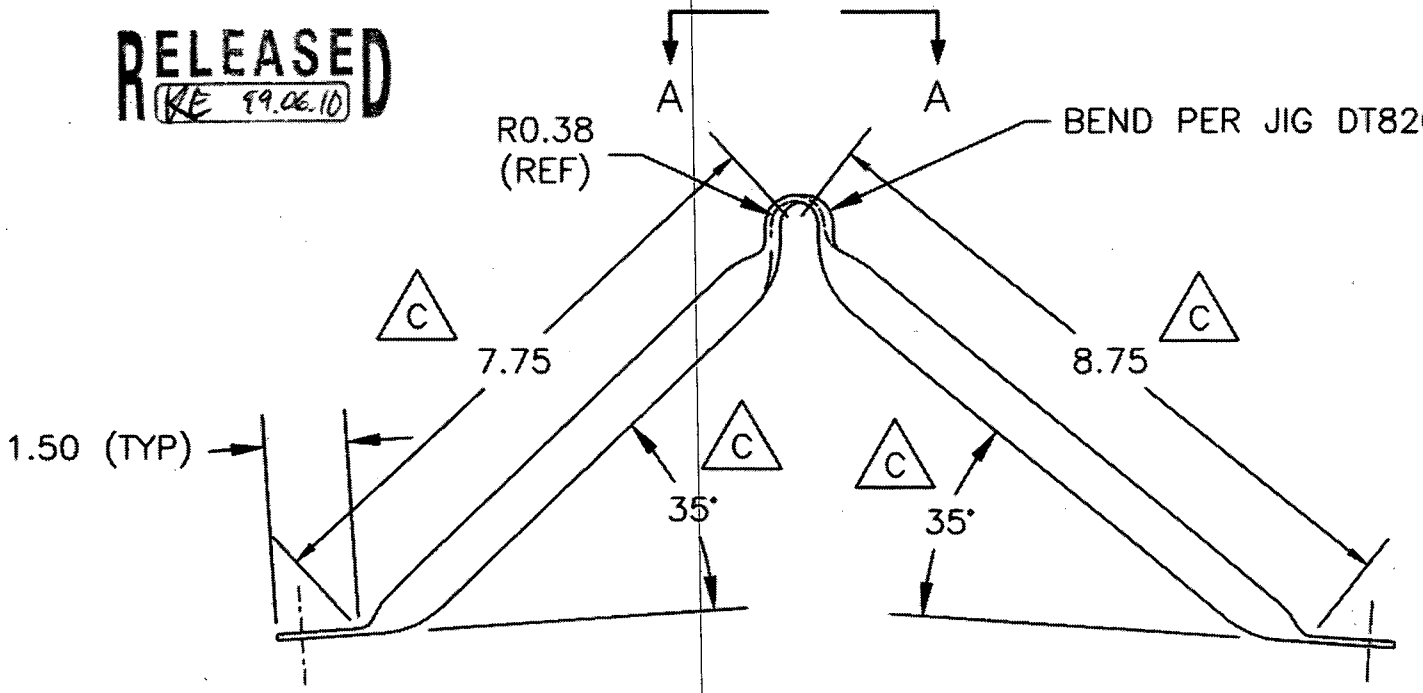
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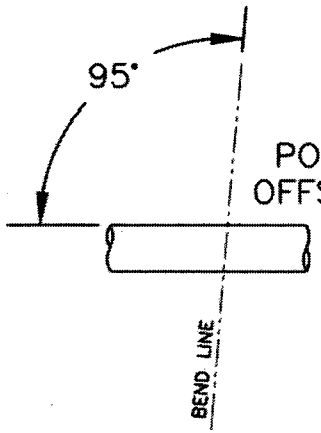
DART

COPY ISSUED

DESIGN JB	DRAWN BY RF	DART AEROSPACE LTD	
CHECKED KE	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE 99.06.07	TITLE MIRROR BRACKET	DRAWING NO. D2013	REV. C
			SHEET 2 OF 3
			SCALE NTS

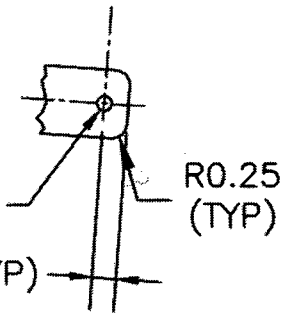
RELEASED
KE 99.06.10





VIEW A–A

D2013–5 LH SHOWN
D2013–6 RH OPPOSITTE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

DART

NO COPY ISSUED

DESIGN JB	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED	DRAWING NO. D2013	REV. C
DATE 99.06.07		TITLE MIRROR BRACKET	SHEET 3 OF 3
			SCALE NTS

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DART AEROSPACE LTD

Description: Mirror Bracket RH 212 Work Order: 112280

Inspection Drawing: D 2013 Rev: C Part Number: D 2013-4

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.50	± 0.030	10.50	V		S Fab-07	
8.50	± 0.030	8.50	V		" " "	
1.50	± 0.030	1.50	V		S Fab-08	
32°	1°	32°	V		" " -05	
42°	1°	42°	V		" " -05	
5°	1°	5°	V		" " -05	

Measured by:	Checked By: DAS 30 9-89	QC inspector:	Engineering Approval (*if necessary*)
FF			
Date 14-04-07	Date 14/6/4/03	Date	Date